

Work Order ID 61393

August 24, 2010 8:39:35 AM



Page 1

Item ID: D2989-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 8/24/10

Start Qty: 2.00



Cust Item ID:

Required Date: 8/30/10

Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 10/8/24 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 cut D2989-3 to length using DT9441 template and cut 45 degree as per dwg D2989 2- remove identification markings 3- deburr

LS 10/09/23 (4x)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/09/24

(4x)

120

0.00



Identify as per dwg & Stock Location:

Backet 64

Packaging

Memo

0.00

Packaging

LS 10/09/23 (4x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 61393

August 24, 2010 8:39:35 AM



Page 2

Item ID: D2989-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 8/24/10

Start Qty: 2.00



Cust Item ID:

Required Date: 8/30/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/27 *[Signature]*
ME
10-9-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

August 24, 2010 8:39:35 AM

Page 1

Work Order ID: 61393



Parent Item: D2989-3



Parent Item Name: Rib


Start Date: 8/24/10

Required Date: 8/30/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3166-3  Basket Hoop | | Manufactured | No | | | 100 | Each | 5.0418 | 0.08 | 0.168421 | | 10/09/23 | |

Location

Loc Qty

Loc Code

WA

5.041821053

55697

2.1053E-05

59266

0.0418

60270

5

3368

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

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121018/24

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D2989-041 | BASKET LID ASSEMBLY |
| 2 | | X | D2989-043 | BASKET LID ASSEMBLY |
| 3 | 1 | | D2506 | LABEL PLATE |
| 4 | 1 | | D2512-7 | RIB |
| 5 | 2 | | D2581 | MOUNTING BRACKET |
| 6 | | 1 | D2989-3 | RIB |
| 7 | | 1 | D2989-4 | RIB |
| 8 | | 2 | D2989-5 | RIB |
| 9 | 2 | | D2989-13 | RIB |
| 10 | 2 | 1 | D2989-17 | RIB |
| 11 | 2 | | D2989-19 | RIB |
| 12 | | 2 | D3182-1 | HINGE |
| 13 | | 2 | D3442-3 | SHIM |
| 14 | | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 15 | 1 | | D3832-3 | MESH, BASKET LID |
| 16 | | 1 | D3832-5 | MESH, BASKET LID |
| 17 | 2 | | D3833-3 | MESH, LID END |
| 18 | | 2 | D3833-5 | MESH, LID END |
| 19 | 1 | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 20 | 1 | | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 21 | | 1 | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 22 | | 1 | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 23 | 1 | | D3852-041 | RIB ASSEMBLY |
| 24 | 1 | | D3852-042 | RIB ASSEMBLY |

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| | | | |
|------------|--|--|--------------|
| D | REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-21/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM | MB | 08.09.24 |
| C | FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD | AJS | 08.06.20 |
| B | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | PH | 05.06.07 |
| A | NEW ISSUE | DS | 00.10.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DS | | |
| CHECKED | DS | DRAWING NO. | REV. D |
| MFG. APPR. | DS | D2989 | SHEET 1 OF 5 |
| APPROVED | DS | TITLE | SCALE |
| DE APPR. | DS | BASKET LID ASSEMBLY | NTS |
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8

7

6

5

4

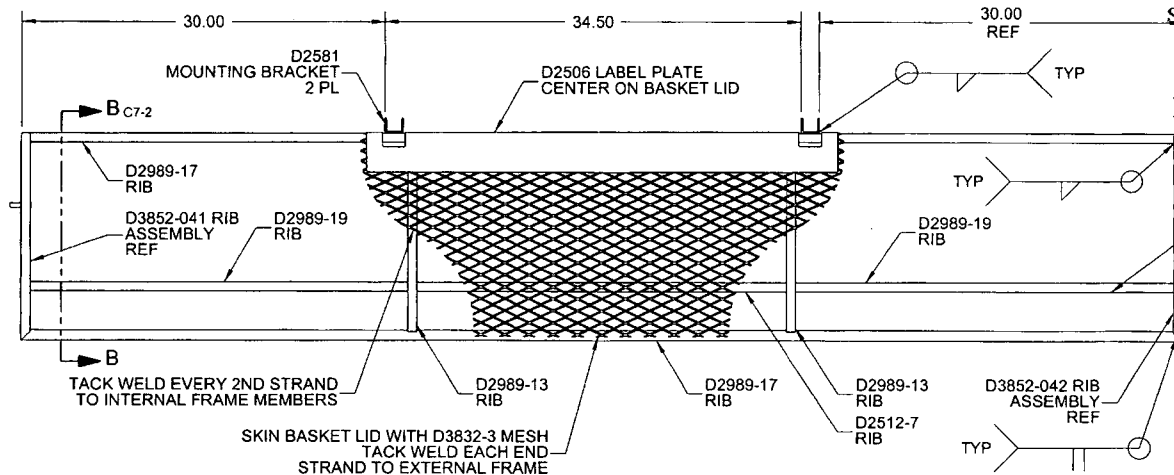
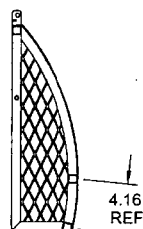
3

2

1

SECTION B-B

D7-2



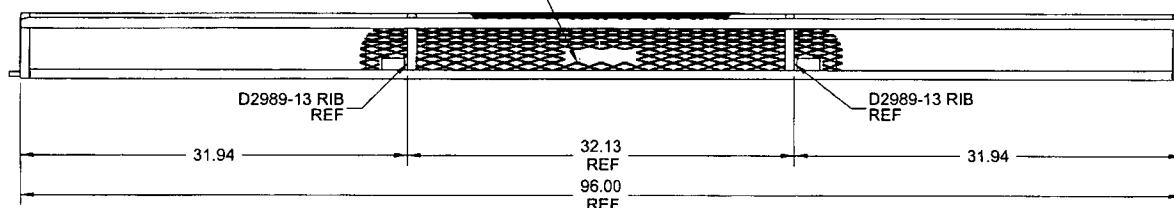
TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID
PAINT THIS SECTION

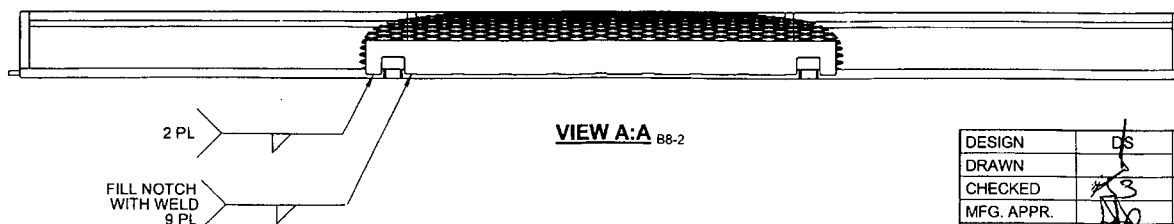
TACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERS

SKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAME

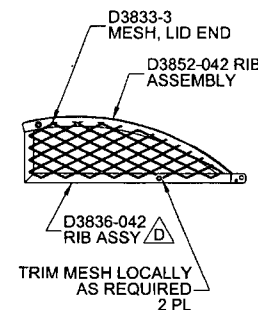
TACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATION



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)






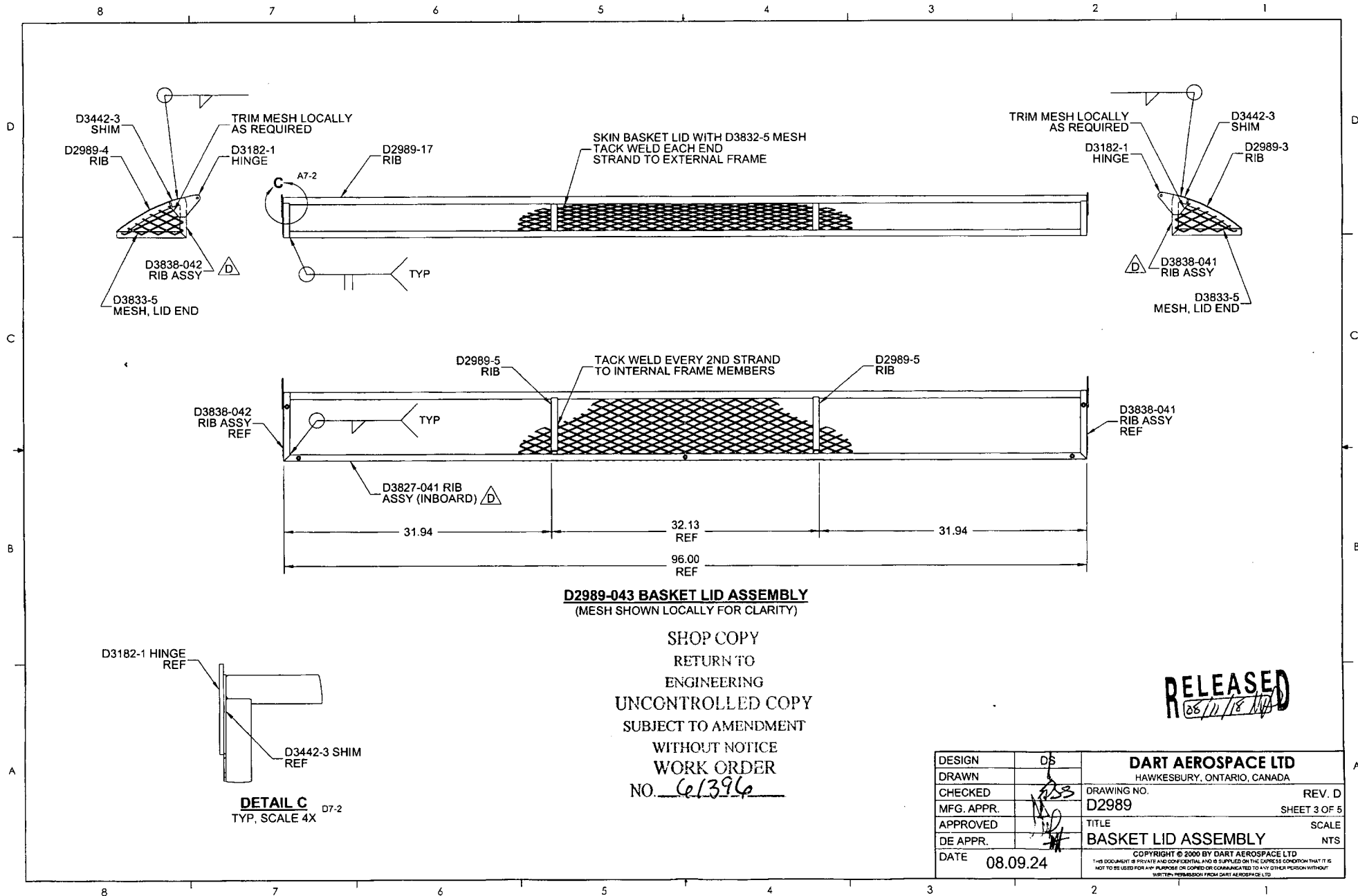
VIEW A:A B8-2



TRIM MESH LOCALLY
AS REQUIRED
2 PL

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| | | | |
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| MFG. APPR. | | D2989 | SHEET 2 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | BASKET LID ASSEMBLY | NT |
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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

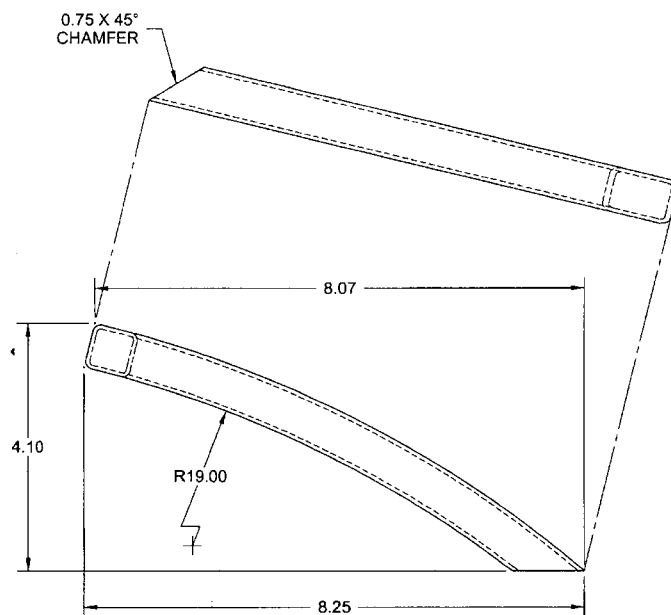
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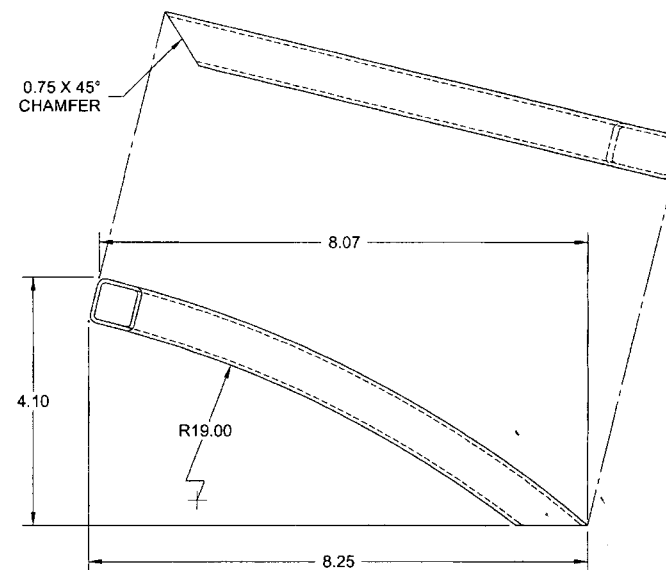
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| CHECKED | DS | DRAWING NO. D2989 | REV. D |
| MFG. APPR. | | | SHEET 3 OF 5 |
| APPROVED | | TITLE | SCALE |
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TYP, SCALE 4X

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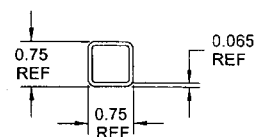
D2989-3 RIB



D2989-4 RIB

NOTES:

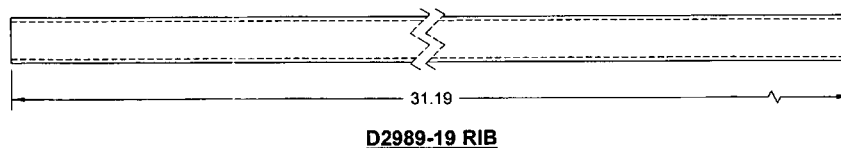
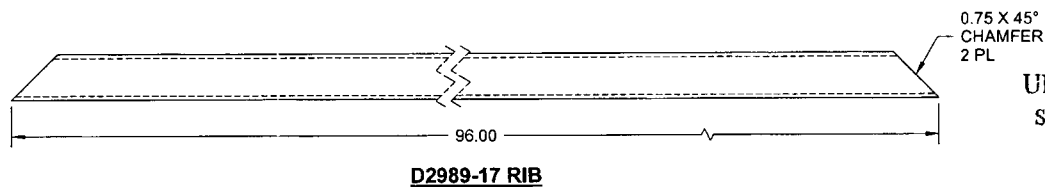
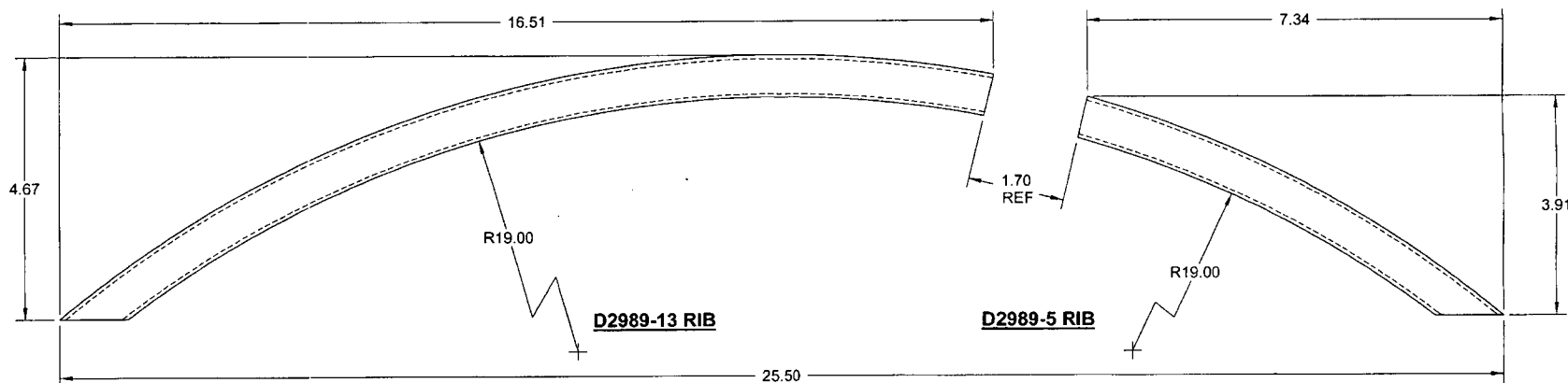
- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



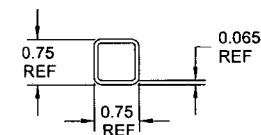
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D2989 | REV. D |
| MFG. APPR. | | | SHEET 4 OF 5 |
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- NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | DS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DS | DRAWING NO. | REV. F |
| MFG. APPR. | DS | D2989 | SHEET 5 OF 5 |
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